Quality Control

	er ID 73302 gust 31, 2011 10:46	6:16 AM										Page 1
Item ID: Revision ID: Item Name:	D3455-1 Spacer		, JM	Accept					Setup	Start Stop	1 18811/87 8	
Start Date: Required Date Reference:		rt Qty: 16,00 q'd Qty: 16.00	401		Cust Item I Customer:	D:						
Approvals:	Process Plan: QC:		Date: 1 - 09-0			ate:		j	Run	Start Stop		
Sequence ID/ Work Center I		ration cription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision	Nbr										
D3455	Rev A	<u> </u>										
100 Hardinge Hardinge CNC Latt		inge CNC LATHE Memo HARDHIN ,□FOLIO	- /		VG D3455 AS REQUIRED			40	0	1		
QC Quality Control	QC2	- Inspect parts off Memo	machine FAI/FAIB	0.00 0.00 10 0.00	J19			40	Ø	<u>, </u>		
120 QC	QC8	- Inspect parts - se	cond check	0.00 A-A	11/09/19			40	4	\$		-

Dart	Aeros	pace	Ltd
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W/O:		WORK ORDER (CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
						-				
					1					
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _				

Disposition: _____ QA: N/C Closed: _____

Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
5475 0755		Description of NC		Corrective Action Section B	Verification	Approval	Approval				
DATE	TE STEP Description of Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC inspector			
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NOTE: Date & initial all entries

Resolution:

Work Order ID 73302

Wednesday, August 31, 2011 10:46:16 AM



Page 2

Item ID:

D3455-1

Accept

Setup Start

Revision ID:

Item Name: **Start Date:**

Spacer

9/1/2011

Start Qty: 16.00

Req'd Qty: 16.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: Tooling:

Date: _____

Date:

Run

Start

Stop

Required Date: 9/15/2011

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

130

Small Fab

Small Fab

Operation

Description

Small Fab

Set Up/ **Run Hours**

0.00

Tool # Plan

Accept Code Qty

Reject Reject Qty -Number

Insp. Stamp

Memo

Memo

Deburr if necessary.

140

Quality Control

OC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location: 57 50.

150

Packaging Packaging

Memo

0.00

0.00

400 Sp 11-09-20-/1

D	art	: A	erc	sp	ac	e L	td
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W/O:				WORK ORDER	CHANGES			, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	
DATE	STEP		PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):		PAR #:	Fault Category:	NCR: Ye	es No DQ	A:	Date: _	
	R	esolution:		Disposition:	QA: N/C	Closed:		Date: _	_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
	_	Description of NC		Corrective Action Section B		Verification	Approval	Annroyal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
		·								

Work Order ID 73302



Page 3

Wednesday, August 31, 2011 10:46:16 AM

Item ID:

D3455-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Spacer

QC:

Start Date:

Required Date: 9/15/2011

9/1/2011

Start Qty: 16.00 Req'd Qty: 16.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Tooling:

Date:

Tool # Plan

Code

Start Run



Date: SPC (Y/N): Date:

Stop



Sequence ID/

Work Center ID

160

QC Quality Control

Memo

QC21- Final Inspection - Work Order Release

Run Hours

Set Up/

0.00

0.00

Accept

Qty

Reject Qty

Reject Insp.

Number Stamp



Dart Aerospace Ltd

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W/O:		and the second of the second o	WO	RK ORDER CHANGE	S	····					
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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					1						
Part No	!l :	PAR #:	Fault Cated	orv:	NCR: Yes	No DQ	1	Date:	<u> </u>		
		esolution:									
NCR:			WORK ORDE	R NON-CONFORMAL	NCE (NCR)					
DATE	STEP	Description of NC	C Corrective Action Section B			verificat			Approval		
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector		

Picklist Print

Wednesday, August 31, 2011 10:46:13 AM

Work Order ID: 73302

Parent Item: D3455-1

Parent Item Name: Spacer

0



Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP REV. A

05.11.17

NEW ISSUE

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINRI 000		Purchased	No			100	f	41.2180	0.022	0.370526		10	

Delrin Round Bar 1"

Location	Loc Qty	Loc Code
MAT055	41.218	
117985	0.407	
1:18257	24.811	
118392	16	

-500

Dart	Aero	space	Ltd
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W/O:		y 1,41 pp 1,41	W	ORK ORDER CHANG	ES				
DATE	STEP	PRC	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									•
Part No	•	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A :	Date: _	-
	R	esolution:	Dispositi	on:	_ QA: N/C C	losed:		Date: _	.
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	73300
		7
Description: Spacer	Part Number:	D3455-1
Inspection Dwg: D3455 Rev: A		Page 1 of 1

	FIRS	ST ARTICLE II	NSPECTI	ON CHE	ECKLIST		
		X First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	omments
Ø0.453	+0.005/-0.000	0,455					
Ø1.00	+0.010/-0.001	1.002		_			
0.065	+/-0.010	-065					
·Y							
Measured by:	12	Audited by:	A.L		Prototype /	Approval:	N/A
Date:	11919	Date:	11/09/19			Date:	N/A
Rev Date A 06.07.11	Change New Issue		1			Revised by	Approved

Dart Aerospace Ltd

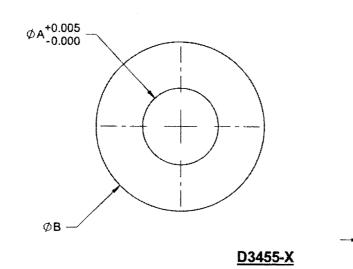
W/O:			V	VORK ORDER CHA	NGES					
DATE	STEP	PROC	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No		PAR #:	_ Fault Ca	tegory:	NCI	R: Yes N	lo DQA	\:	Date:	
			Disposition: Q/							
NCR:		W	ORK OR	DER NON-CONFOR	RMANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Initial Action Descrip		Section B	verific		Verification	Approval	Approval
	J.L.	Section A	Chief Eng	Chief Eng	ЮП	Date	Section	on C	Chief Eng	QC Inspector
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DESIGI R	-	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECK	ED.	APPROVED	DRAWING NO. D3455	REV. A SHEET 1 OF 1			
DATE	05,0	9.02	TITLE SPACER	SCALE 2:1			
Α	Ó	5.09.02	NEW ISSUE				

RELEASED 05.12.09





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1) SPECIFICATION: D3455-X SPACER

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

 DASH No.	A (in)	B (in)	C (in)	
€ ं-1	0.453	1.00	0.065	\supset
-3	0.386	1.00	0.050	

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	FS			
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								,
							,	
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Yes I	No DQA: _	Date: _	
	R	esolution:	Disposition		_ QA: N/C Clo	sed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR)		
		Description of NC		ion B	Verificatio	n Approval	Approval	
DATE	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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